

WHAT IS CLAIMED IS:

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- 5 1. A light emitting device comprising:  
a substrate;  
an EL element formed over a substrate; and  
an absorption film formed over the EL element;  
wherein the EL element is interposed between the substrate and the absorption  
film.

- 10 2. A device according to claim 1, wherein the absorption film is a hygroscopic  
film.

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- 15 3. A device according to claim 1, wherein the absorption film comprises  
alkaline-earth metal.

4. A device according to claim 1, wherein the inorganic has 1 to 3  $\mu\text{m}$   
thickness.

- 20 5. A device according to claim 1, wherein the device is selected from the group  
consisting of a video camera, a digital camera, a goggle type display, a navigation  
system, an audio apparatus, a note type personal computer, a game apparatus, a portable  
apparatus, and an image play back device equipped with a recording medium.

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- 25 6. A light emitting device comprising:  
a first substrate;  
an EL element formed over the first substrate;  
an absorption film formed over the EL element; and  
a sealing substrate connected to the first substrate through a sealant;  
wherein the EL element is provided in a space surrounded by the first substrate,  
30 the sealant, and the sealing substrate.

7. A device according to claim 6, wherein the absorption film is a hygroscopic

film.

8. A device according to claim 6, wherein the absorption film comprises alkaline-earth metal.

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9. A device according to claim 6, wherein the inorganic has 1 to 3  $\mu\text{m}$  thickness.

10. A device according to claim 6, wherein the sealant is not overlapped with the inorganic film.

11. A device according to claim 6, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

12. A light emitting device comprising:  
a substrate;

an EL element formed over the substrate, the EL element comprising an anode,  
20 an EL layer, and a cathode;  
an absorption film formed over the cathode;  
wherein the EL element is interposed between the substrate and the absorption film.

13. A device according to claim 12, wherein the absorption film is a hygroscopic film.

14. A device according to claim 12, wherein the absorption film comprises alkaline-earth metal.

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15. A device according to claim 12, wherein the inorganic has 1 to 3  $\mu\text{m}$  thickness.

16. A device according to claim 12, wherein the absorption film is formed over the anode, and the EL layer, the cathode, and the absorption film are successively formed under an inert gas atmosphere.

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17. A device according to claim 12, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

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18. A light emitting device comprising;

a substrate;

a TFT formed over the substrate,

an EL element electrically connected with the TFT; and

an absorption film formed over the EL element;

wherein the EL element is interposed between the substrate and the absorption

film.

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19. A device according to claim 18, wherein the absorption film is a hygroscopic film.

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20. A device according to claim 18, wherein the absorption film comprises alkaline-earth metal.

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21. A device according to claim 18, wherein the inorganic has 1 to 3  $\mu\text{m}$  thickness.

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22. A device according to claim 18, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

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23. A light emitting device comprising:  
a substrate;  
an EL element formed over a substrate; and  
an inorganic hygroscopic film formed over the EL element for absorbing  
5 moisture;  
wherein the EL element is enclosed by the substrate and the inorganic  
hygroscopic film.

24. A device according to claim 23, wherein the inorganic hygroscopic film  
10 comprises alkaline-earth metal.

25. A device according to claim 23, wherein the inorganic film has 1 to 3  $\mu\text{m}$   
thickness.

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26. A device according to claim 23, wherein the device is selected from the  
group consisting of a video camera, a digital camera, a goggle type display, a navigation  
system, an audio apparatus, a note type personal computer, a game apparatus, a portable  
apparatus, and an image play back device equipped with a recording medium.

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27. A light emitting device comprising:  
a first substrate;  
an EL element comprising an organic light emitting layer formed over a  
substrate;

28. A device according to claim 27, wherein the EL element further comprises  
an anode, a hole injection layer, a hole transfer layer, and a cathode.

29. The device according to claim 27, wherein the barrier film comprises a  
material selected from the group consisting of carbon, silicon oxide, silicon nitride, and

copper phthalocyanine.

30. A device according to claim 27, wherein the inorganic hygroscopic film comprises alkaline-earth metal.

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31. A device according to claim 27, wherein the inorganic film has 1 to 3  $\mu\text{m}$  thickness.

32. A device according to claim 27, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

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33. A light emitting device comprising:

a first substrate;

an EL element comprising an organic light emitting layer formed over a substrate;

a barrier film covering the EL element;

an inorganic hygroscopic film formed over the barrier film wherein the barrier film is interposed between the inorganic hygroscopic film and the EL element; and

20 a second substrate opposed to the first substrate with the EL element disposed therebetween wherein a space between the first and second substrates are hermetically sealed by a sealant.

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34. A device according to claim 33, wherein a metal film covers the sealant and the second substrate.

35. A device according to claim 34, wherein the metal film comprises a material selected from the group consisting of Al and Mg.

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36. A device according to claim 33, wherein the space is filled with an inert gas selected from the group consisting of nitrogen and a noble gas.

37. A device according to claim 33, wherein the EL element further comprises an anode, a hole injection layer, a hole transfer layer, and a cathode.

5 38. The device according to claim 33, wherein the barrier film comprises a material selected from the group consisting of carbon, silicon oxide, silicon nitride, and copper phthalocyanine.

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39. A device according to claim 33, wherein the inorganic hygroscopic film  
10 comprises alkaline-earth metal.

40. A device according to claim 33, wherein the inorganic film has 1 to 3  $\mu\text{m}$  thickness.

15 41. A device according to claim 33, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

20 42. A light emitting device comprising:  
a first substrate;  
a plurality of switching elements formed over the first substrate, each of the switching elements comprising a thin film transistor;  
a plurality of EL elements formed over the first substrate;

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20 connected to the switching elements, each of the EL elements comprising an organic light emitting layer;

a driver circuit comprising thin film transistors formed over the first substrate;  
an inorganic hygroscopic film formed over the plurality of EL elements and the driver circuit; and

30 a second substrate opposed to the first substrate with the EL element disposed therebetween wherein a space between the first and second substrates are hermetically sealed by a sealant.

43. A device according to claim 42, wherein a metal film covers the sealant and the second substrate.

5 44. A device according to claim 43, wherein the metal film comprises a material selected from the group consisting of Al and Mg.

45. A device according to claim 42, wherein the space is filled with an inert gas selected from the group consisting of nitrogen and a noble gas.

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46. A device according to claim 42, wherein the EL element further comprises an anode, a hole injection layer, a hole transfer layer, and a cathode.

15 47. A device according to claim 42, wherein the inorganic hygroscopic film comprises alkaline-earth metal.

48. A device according to claim 42, wherein the inorganic film has 1 to 3  $\mu\text{m}$  thickness.

20 49. A device according to claim 42, wherein the device is selected from the group consisting of a video camera, a digital camera, a goggle type display, a navigation system, an audio apparatus, a note type personal computer, a game apparatus, a portable apparatus, and an image play back device equipped with a recording medium.

50. A method of manufacturing a light-emitting device comprising the steps of:  
providing a film formation apparatus;  
forming an EL layer over a substrate in the film formation apparatus;  
forming an inorganic hygroscopic film over the EL layer in the film formation apparatus;

30 wherein the substrate is prevented from contacting an air outside of the film formation apparatus after the formation of the EL layer and until the formation of the inorganic hygroscopic film is finished;

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51. A method of manufacturing a light emitting device according to claim 50, wherein the inorganic hygroscopic film comprises alkaline-earth metal.

5 52. A method of manufacturing a light emitting device according to claim 50, wherein the inorganic film has 1 to 3  $\mu\text{m}$  thickness.

53. A method of manufacturing a light emitting device comprising the steps of:  
providing a film formation apparatus having a plurality of chambers;

10 forming an EL layer over a substrate in one chamber of the film formation apparatus;

forming an inorganic hygroscopic film over the EL layer in an another chamber of the film formation apparatus;

15 wherein the steps from forming the EL layer to forming the inorganic hygroscopic film are performed without exposing the substrate to moisture and oxygen.

54. A method of manufacturing a light emitting device according to claim 12, wherein the inorganic hygroscopic film comprises alkaline-earth metal.

20 55. A method of manufacturing a light emitting device according to claim 12, wherein the inorganic film has 1 to 3  $\mu\text{m}$  thickness.

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